

Date: Wednesday, 11/03/2009 9:09:23 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
 Job Number : 46407
 Estimate Number : 12337
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 46407
 Part Number : D34923
 Drawing Number : D3492 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 18/03/2009 Qty: 60 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 06.03.21 New Issue JLM
 Est Rev: B 06-08-28 As per Rev B JLM
 Est Rev: C 07-12-06 Rev C dwg DD verified by: EC
 Est Rev: D 08-05-07 add note to count qty DD verified by: JLM
 Est Rev: E 09-02-18 remove o'ring DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.0656 f(s)/Unit Total : 3.9375 f(s)
 6061-T6 Round Bar .750"
 (M6061T6R750)
 Batch: 110791

SA 09/03/11

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492
 Dwg Rev: C
 Folio Rev: R

SA 09/03/11

66

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/03/11

66

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 09/03/13

Date: Wednesday, 11/03/2009 9:09:23 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 46407

Part Number: D34923

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



66

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/03/17

6.0

POWDER COATING

POWDER COATING



m110939

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

X66

START TIME:

9:15

OVEN TEMPERATURE:

320°

FINISH TIME:

10:45

CMO/FL

09/03/18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-18

X66

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-A

FL 09/03/18

66

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19

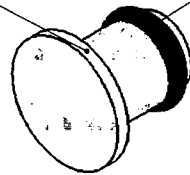
Job Completion



U 09.03.19

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

10/0 46407

~~UNDER REVIEW~~
02.04.2 08.11.12
OK NSS

DEO ATTACHED

RELEASED
03.11.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
DRAWING NO. D3492		SHEET 1 OF 2	
TITLE PLUG		SCALE 2:1	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

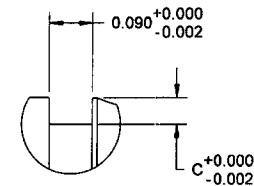
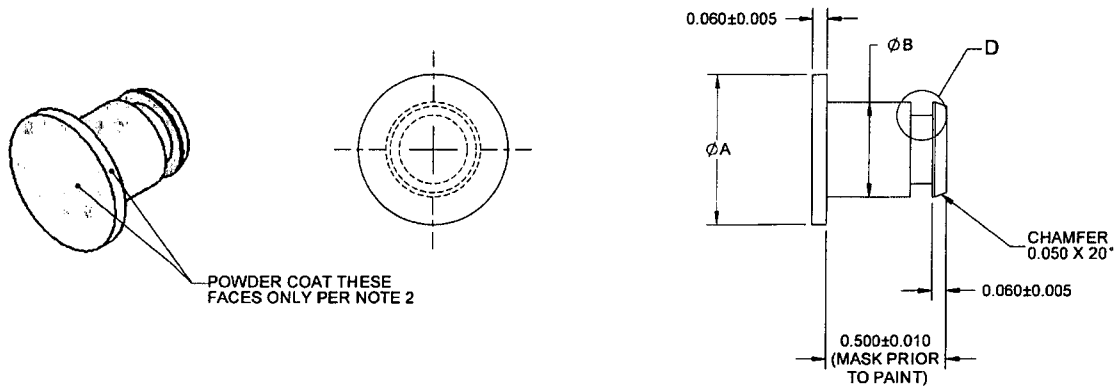
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW

01.04.11 PBA

DEM-B-EN D-492-3

REV. 06 (MIKE STALLER)

ASS 08.11.12

OKing

DEO ATTACHED

RELEASED

07.11.16

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3492	SHEET 2 OF 2
DATE	07.10.05	TITLE PLUG	SCALE 4:1
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10